



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200



D3391-025
Job Sheet 167283-D

Part No: D3391-025

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 12/18/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Customer: Falcon Aviation Services (CFALC01)

PO Box 62030 Abu Dhabi, United Arab Emirates ph:011 971 50 445 0187 fx:+971 2 444 0022.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/15/17	0.00	0.00	Start Up Skid tubes		
100	Mori Seiki	1 pcs		12/15/17	2.49	4.17	Mori Seiki TL-40		PMP
110	QC	1 pcs		12/15/17	0.00	0.00	QC2		PMP
112	QC	1 pcs		12/15/17	0.00	0.00	QC5		PD 17-11-13
120	CNC Vertical Machining	1 pcs		12/16/17	0.00	2.63	HAAS 1		K+ 17-12-04
130	QC	1 pcs		12/16/17	0.00	0.00	QC2		K+ 17-12-04
140	QC	1 pcs		12/16/17	0.00	0.00	QC8		J.C.-L 17-12-11
150	Skid tubes	1 pcs		12/16/17	0.00	1.03	Skid tubes		MLG
160	CNC Bend Skid tubes	1 pcs		12/16/17	0.00	1.33	CNC Bend Skid tube		MLG
170	QC	1 pcs		12/16/17	0.00	0.00	QC5		BE
180	Skid tubes	1 pcs		12/16/17	0.00	1.03	Skid tubes		MLG
190	QC	1 pcs		12/16/17	0.00	0.00	QC5		ML 17-12-19
200	HandFinish	1 pcs		12/16/17	0.00	0.58	HandFinish1		2017-12-17 JSC
210	QC	1 pcs		12/16/17	0.00	0.00	QC7		17-12-21 ML
220	Skid tubes	1 pcs		12/16/17	0.00	1.41	Skid tubes		AP 2017/12/20 MLG
230	QC	1 pcs		12/16/17	0.00	0.00	QC5		17-12-21 ML
235	HandFinish	1 pcs		12/16/17	0.00	0.58	HandFinish2		2017-12-21 JSC
240	Spray Paint	1 pcs		12/16/17	0.00	0.25	Spray Paint		ML
250	QC	1 pcs		12/16/17	0.00	0.00	QC14		17-12-27
260	HandFinish	1 pcs		12/18/17	0.00	0.58	HandFinish4		DAS
270	QC	1 pcs		12/18/17	0.00	0.00	QC5		38
280	Packaging	1 pcs		12/18/17	0.00	0.00	Packaging3		9-89
290	QC21-SA	1 Ea		12/18/17	0.00	0.00	QC21		

Part Op 100 - Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: 5 ***ensure steady rest is turning true*** REMOVE
Descriptions: STEADY REST AND MACHINIG MARKS***

120 - 1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: 5

140 - ***INSPECT INSIDE BORE***

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160 - Form as per Dwg D3391 Using Bend Prog 3391025

180 - 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391 (Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig. *****Do Not Open To Finished Size***** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5-Open wearplate holes to 0.297" and c'bore as per dwg D3391 6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8- Scribe batch # on fwd end



S008533

Dart Aerospace Ltd.

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Hawkesbury, ON K6A 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com
www.dartaerospace.com



Aft Tube Assembly

PART NO: D3391 - 025

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 11/09/17

Job No: 167283 - D



220 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: M137712 exp. date : 2018/01 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Debur
 235 - AND REALODINE AS PER PAR09-043
 240 - PRIME AS PER DWG AND QSI005 4.2.1.3.3
 260 - 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 _____
 Sikaflex expiry date: _____ 3- INSTALL WEARPLATES AS PER DWG
 290 - 5- Detail DD, open (5) forward wearplate holes 0.375", then use DT10247 and drill holes for nutplates and c'sink.
 6-Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX FARTHEST AFT HOLES ONLY*** 7-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8-Debur 9- Scribe batch # on fwd end

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6014-090	1	42	0	0
220-Skidtubes	D3670-4-200 <u>B165393</u>	4	79	0	0
260-HandFinish	ALS4-1032-130 <u>5007279</u>	8	1,343	0	0
	D4095-047 <u>F164735</u>	1	20	0	0
	D4095-049	1	18	0	0
	MS20601-AD4W3 <u>S016824</u>	12	150	0	0
	MS20601-AD4W7 <u>M137148</u>	8	313	0	0
	MS21075L5 <u>F1138042</u>	10	173	0	0
270-QC	ALS4-1032-225 <u>138042</u>	4	897	0	0
	AN3C4A <u>5000533</u>	6	1,670	0	0
	AN3C5A <u>5019396</u>	4	364	0	0
	D2646 <u>F164005</u>	1	151	0	0
	D3672-1 <u>F150074</u>	2	1,777	0	0
	NAS1149C0332R	10	4,758	0	0
	<u>F11135948-2</u>				
	<u>F11138409-1</u>				

Part Specifications

Specifications could not be found.

Plex 10/27/17 1:53 PM dart.Michaud-Febrille.Victoria

OP 100 06014-090 B139427

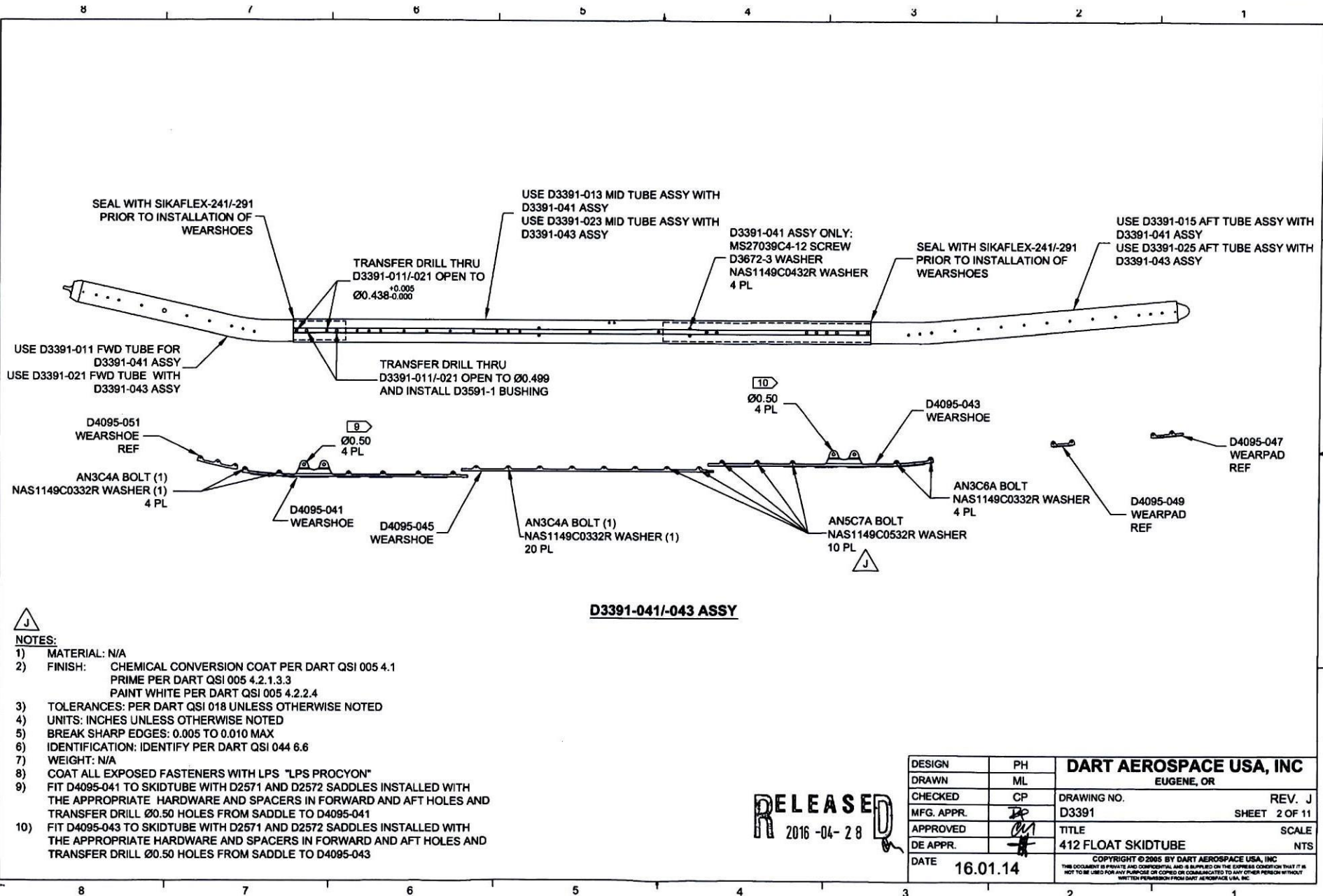
D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3C4A	BOLT
4	4	AN3C6A	BOLT
10	10	AN5C7A	BOLT
28	28	NAS1149C0332R	WASHER
10	10	NAS1149C0532R	WASHER
4		MS27039C4-12	SCREW
4		NAS1149C0432R	WASHER

J

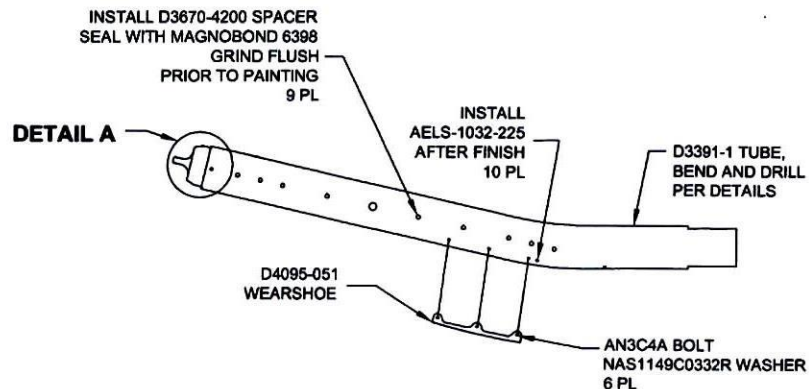
J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	16.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 1 OF 11
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	412 FLOAT SKIDTUBE	NTS
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ECN 16-96

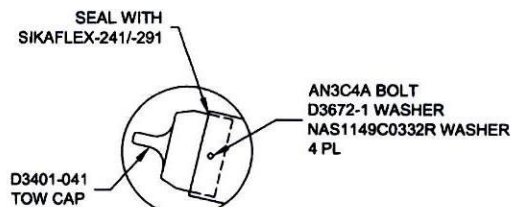


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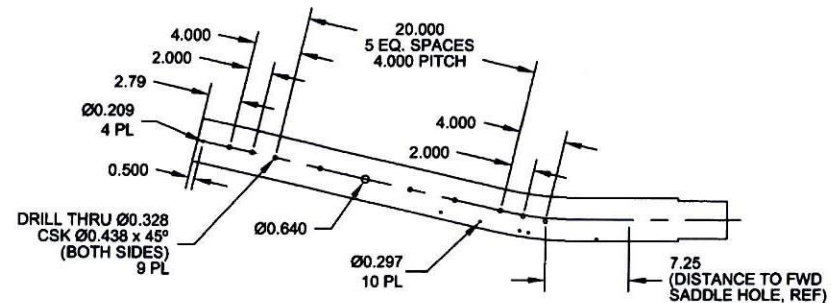
D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL



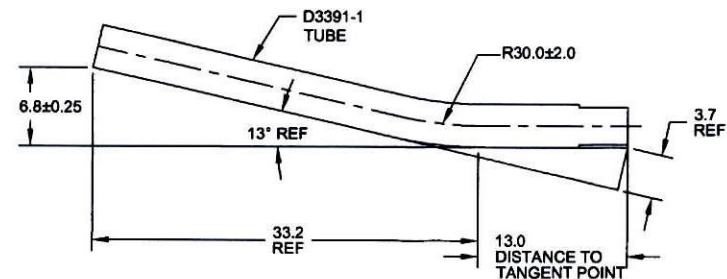
DETAIL A
SCALE 2X

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

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INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



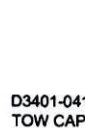
INSTALL
AELS-1032-225
AFTER FINISH
10 PL

D4095-051
WEARSHOE

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/291



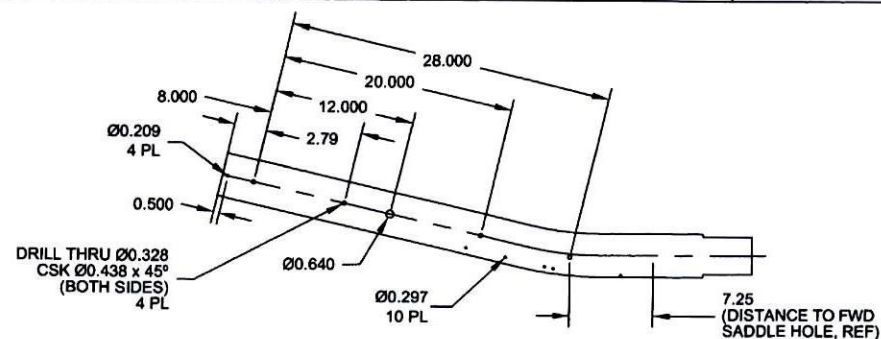
D3401-041
TOW CAP

AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

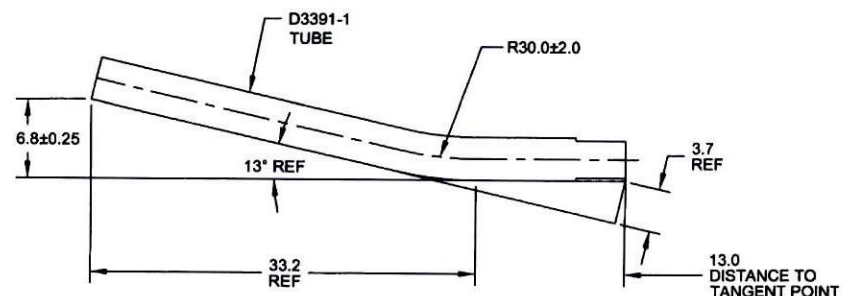
DETAIL B SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



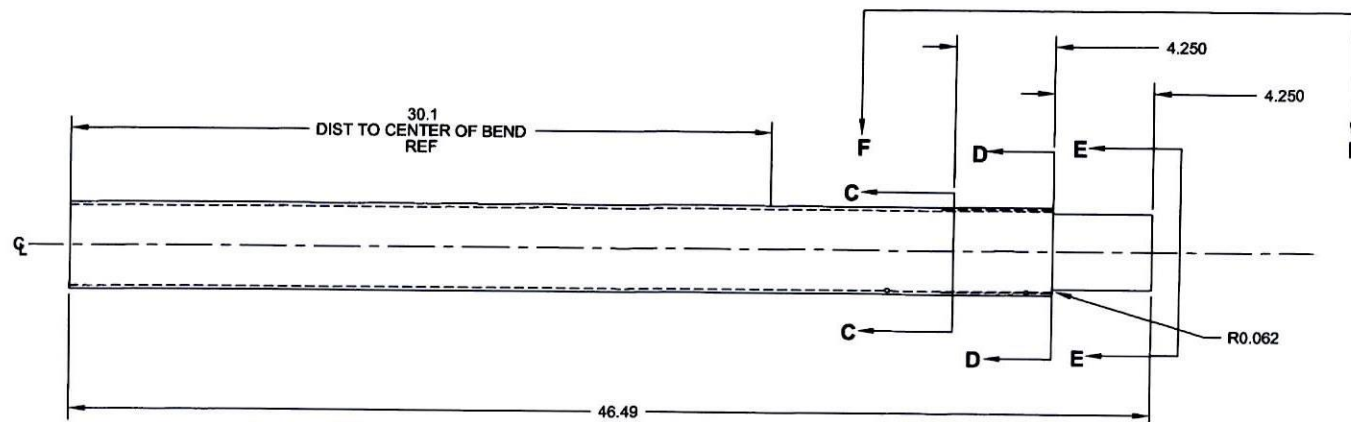
D3391-021 DRILLING DETAIL



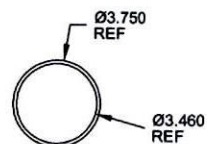
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

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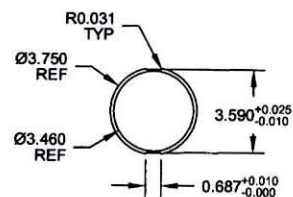
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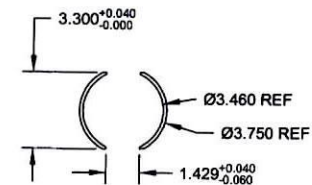
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



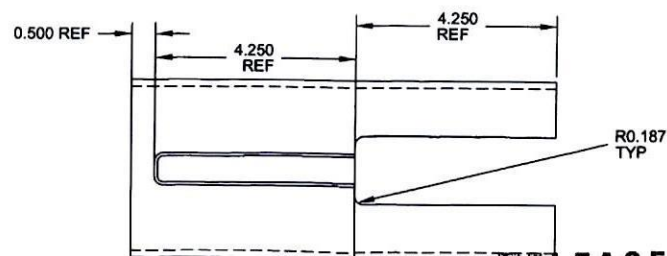
SECTION C-C



SECTION D-D



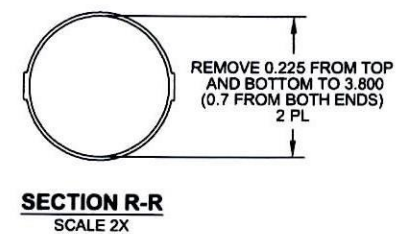
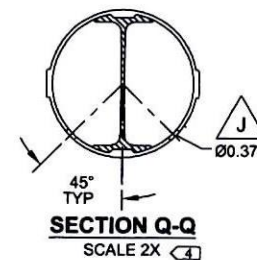
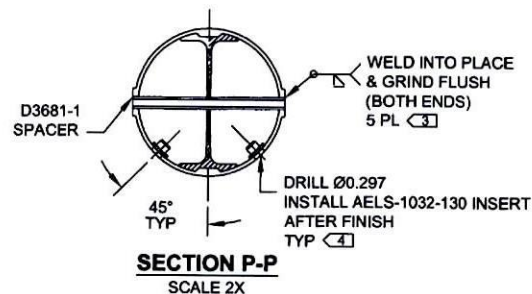
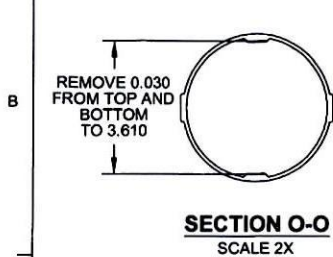
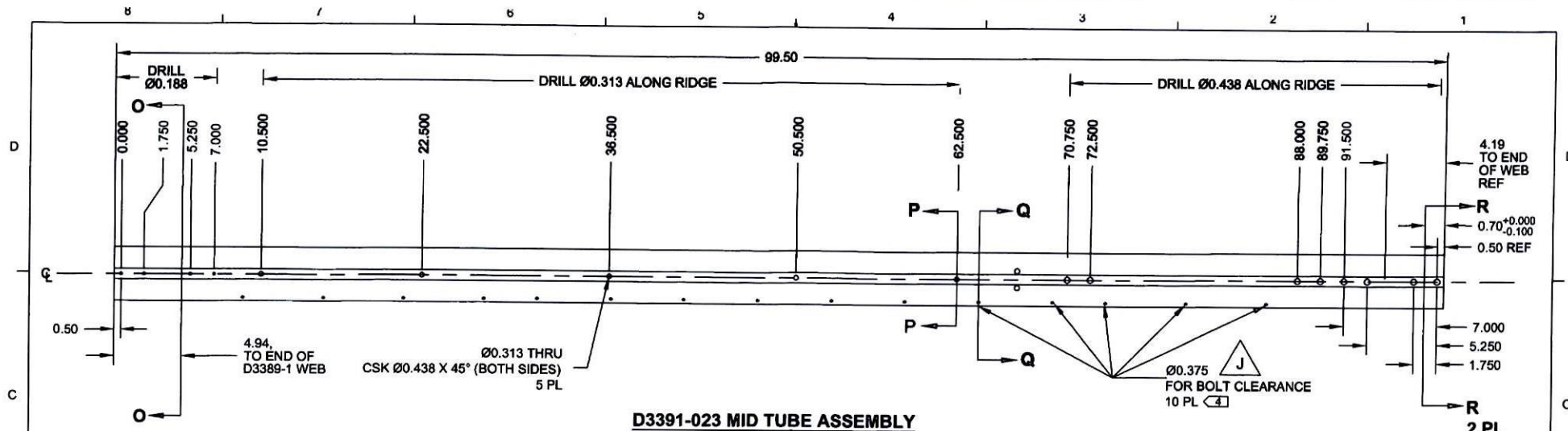
SECTION E-E



VIEW F-F
SCALE 2X

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D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

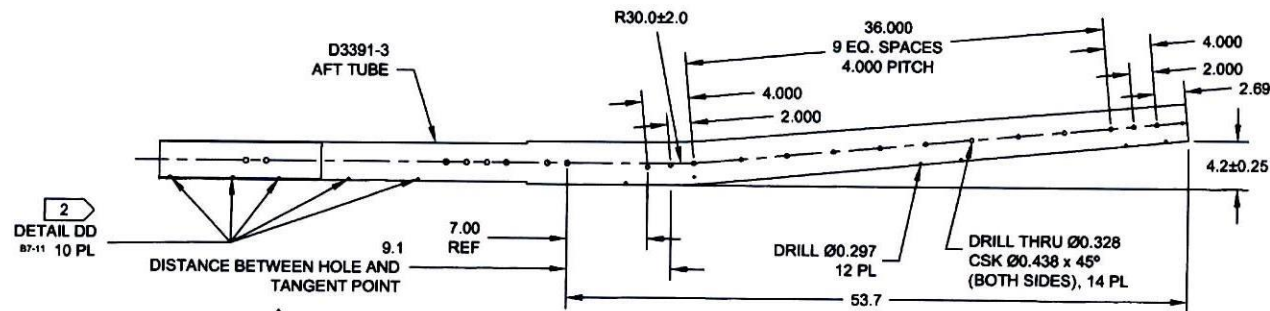
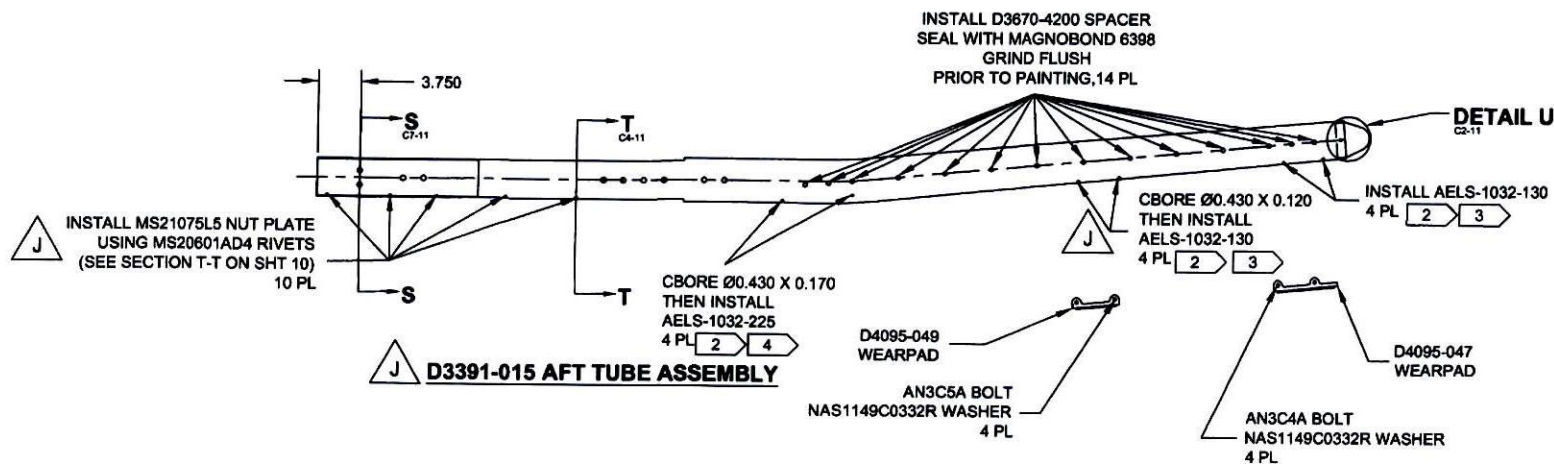


D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

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D3391-015 AFT TUBE ASSEMBLY PARTS LIST

QTY -015	PART NUMBER	DESCRIPTION
X	D3391-015	AFT TUBE ASSEMBLY
1	D2646	AFT CAP
1	D3391-3	AFT TUBE
14	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
4	ALS4-428-165	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE, FLOATING
10	NAS1149C0332R	WASHER

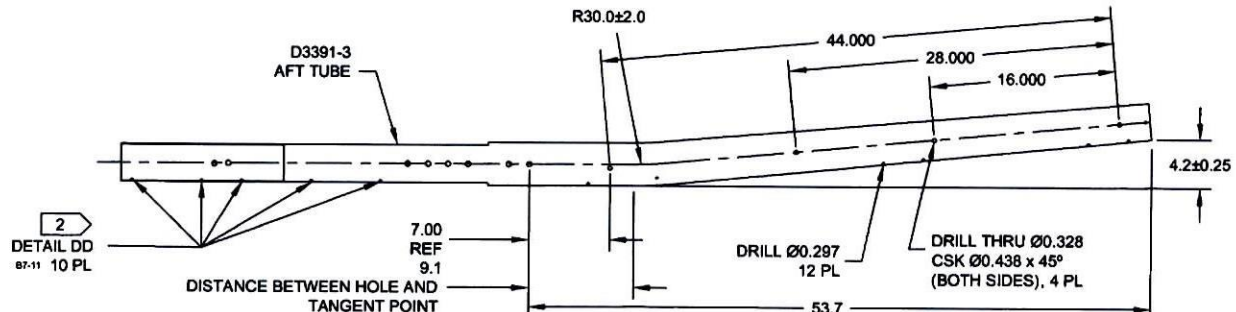
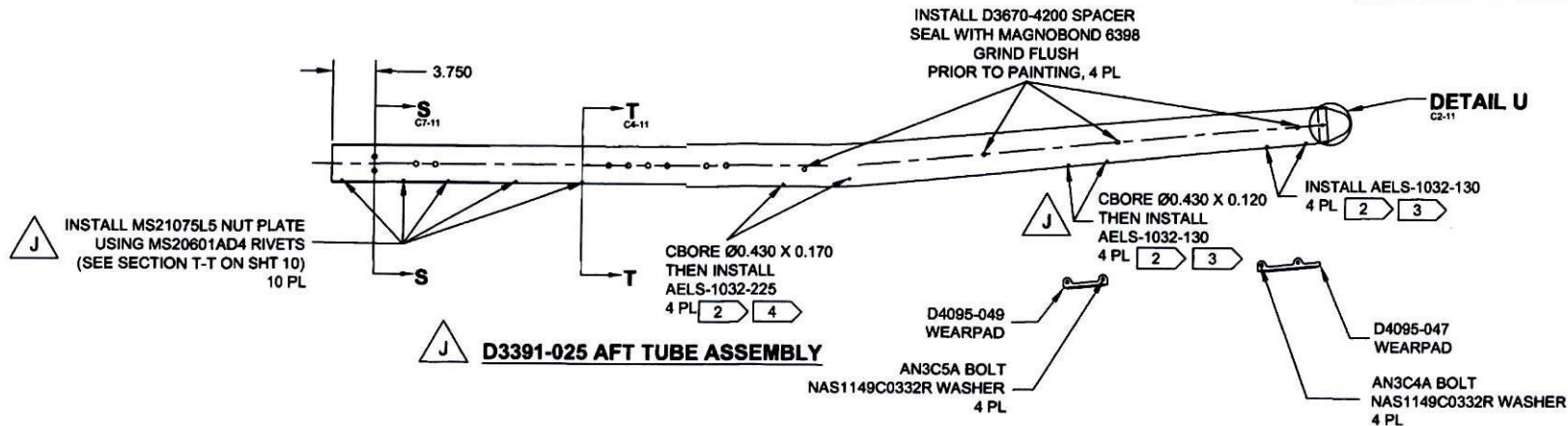
NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. C'BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

BENDING AND DRILLING DETAIL

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2016-04-28

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D3391-025 AFT TUBE ASSEMBLY PARTS LIST

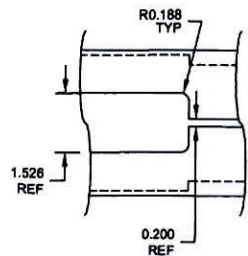
QTY	PART NUMBER	DESCRIPTION
X	D3391-025	AFT TUBE ASSEMBLY
1	D2646	AFT CAP
1	D3391-3	AFT TUBE
4	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE FLOATING
10	NAS1149C0332R	WASHER

NOTES:

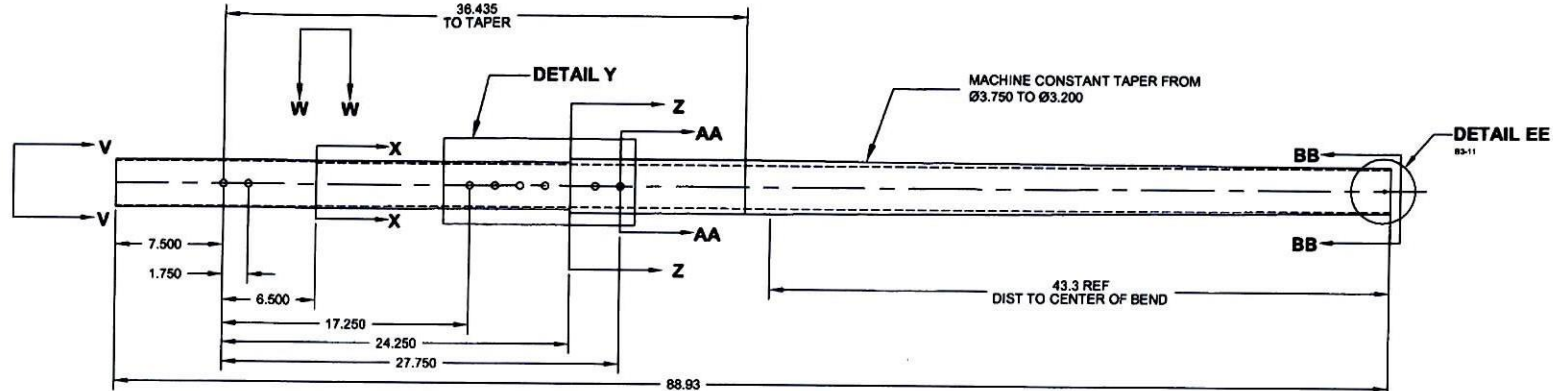
- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. C'BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

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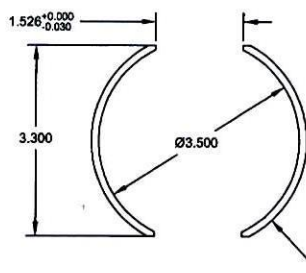
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		AFT TUBE ASSEMBLY	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



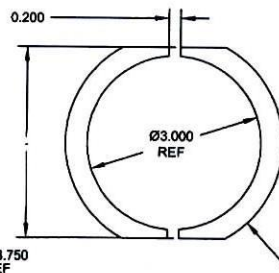
VIEW W-W
SCALE 4X



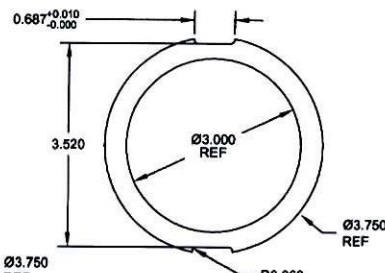
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090)



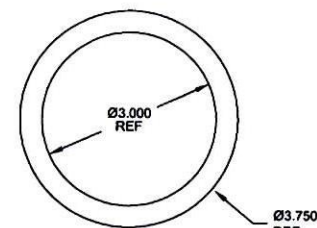
SECTION V-V
SCALE 4X



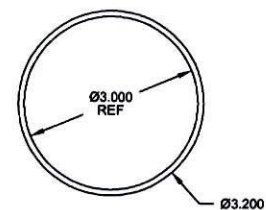
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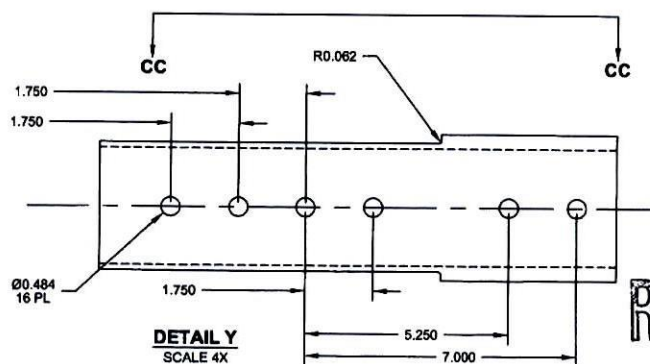
SECTION Z-Z
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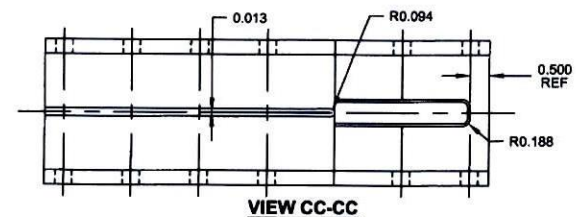
SECTION AA-AA
SCALE 4X



SECTION BB-BB
SCALE 4X



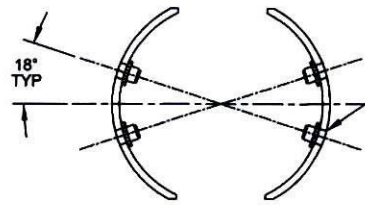
DETAIL Y
SCALE 4X



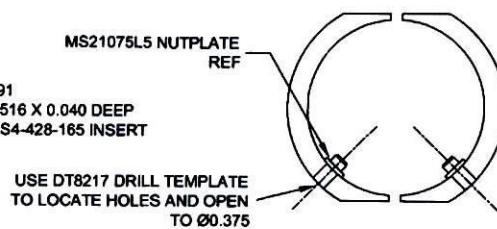
VIEW CC-CC

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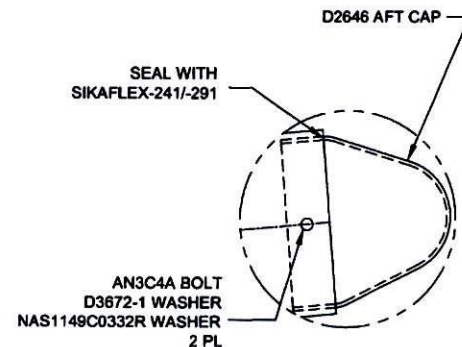
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CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DEF	D3391	SHEET 10 OF 11
APPROVED	DEF	TITLE	SCALE
DE APPR.	DEF	412 FLOAT SKIDTUBE	NTS
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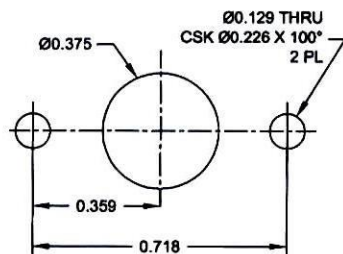
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SCALE 5X



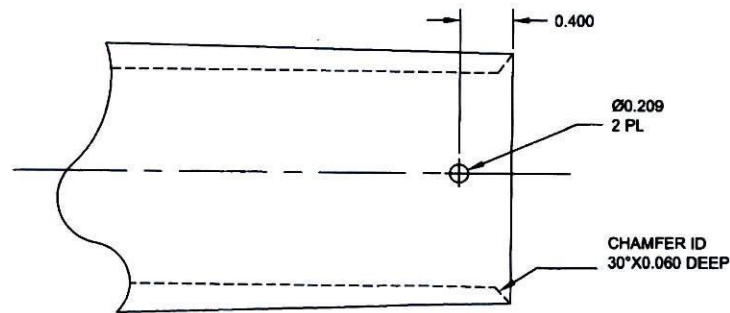
SECTION T-T
SCALE 5X
5 PL



DETAIL U
SCALE 5X



DRILLING DETAIL DD
SCALE 10X



DETAIL EE
SCALE 2X

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

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DART AEROSPACE LTD		Work Order: 167 283-D
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.0	✓		TAPE	
3.500	+/-0.010	3.503	✓		VERN 08	
Ø3.200	+/-0.010	3.198	✓			
Ø3.750	+/-0.010	3.748	✓			
30° x 0.060 chamfer	+/-0.010	.072	✓			
88.93	+/-0.030	88.935	✓		TAPE	

Measured by: PMP	Date: 2017-11-03
Audited by: PD	Date: 11.11.13

HAAS Section						
1.526	+0.000/-0.030	1.510	✓		KT-05	vern
7.500	+/-0.010	7.500	✓		" "	" "
27.750	+/-0.010	27.750	✓		TAPE	
31.750	+/-0.010	31.750	✓		" "	" "
35.250	+/-0.010	35.250	✓		" "	" "
3.300	+/-0.010	3.300	✓		" "	" "
0.200	+/-0.010	0.200	✓		KT-05	vern
3.520	+/-0.010	3.520	✓		AB 10	micro
0.687	+0.010/-0.000	0.689	✓		KT-05	vern
R0.062	+/-0.010	0.0625	✓		R-G	
Ø0.484	+0.005/-0.001	0.485	✓		KT-05	vern

Measured by: 1K	Date: 11-12-04
Audited by: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

